

Work Order ID 68870

Wednesday, May 04, 2011 1:53:50 PM

Page 1

Item ID: D4149-3

Accept

Revision ID:

Item Name: Spacer

Start Date: 4/21/2011 Start Qty: 20.00

Required Date: 5/6/2011 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4149

C

100

Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

4.00" LONG

SL 11/05/05

(20)

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLI FA942 AND DWG

FOLIO REV: AA

DWG REV: C

SL 11/05/09

(20)

DEBURR

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Item ID: D4149-3

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Required Date: 5/6/2011 Req'd Qty: 20.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00 JL 11/05/20



QC

Memo

0.00

(20)

Quality Control

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

R9 11.5.10

20

Quality Control

170

Identify as per dwg & Stock Location: 133

0.00



Packaging

Memo

0.00

11/5/10

(20)

Packaging

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Item ID: D4149-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 4/21/2011 Start Qty: 20.00

Cust Item ID:

Required Date: 5/6/2011 Req'd Qty: 20.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/11 [Signature]
ME
11-05-11

Picklist Print

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Page 1

Work Order ID: 68870



Parent Item: D4149-3



Parent Item Name: Spacer

Start Date: 4/21/2011

Required Date: 5/6/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP REV:A NEW ISSUE 10-06-24 JLM VERIFIED BY:DD IPP
Rev:B 11.03.03 as per revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M303B1.000X1.000

Purchased

No

100

f

18.7420

0.33333333

7.017544



11/05/05

303 BAR 1" X 1"

Location

Loc Qty

Loc Code

MAT050

18.742

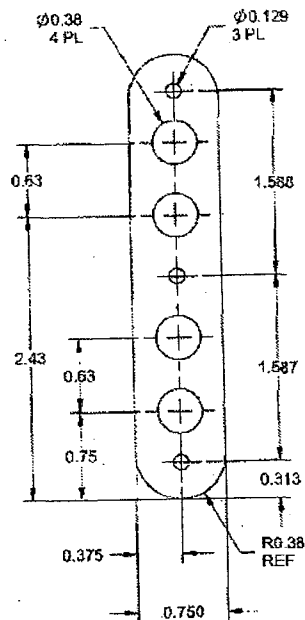
113719

6.742

117049

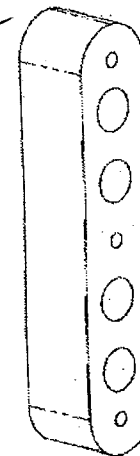
12

7.0



D4149-3 SPACER

w/068870



- NOTES:**
- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A562
REF DART SPEC MS304B OR MS303B
 - 2) FINISH: NONE
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

RELEASED
2011-02-24

DESIGN	MB	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D4149	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		AFT X-TUBE LUG ASSY	NTS
DATE	11.02.22	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS NOT TO BE RELEASED OR DISCLOSED TO THE PUBLIC OR ANY OTHER PARTY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD	

DART AEROSPACE LTD		Work Order:	68870
Description: Spacer		Part Number:	D4149-3
Inspection Dwg: D4149	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by:	SL	Audited by:	29	Preliminary Approval:	N/A
Date:	11/15/05	Date:	11.5.10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	10.08.04	New Issue	KJ	